



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

U/R

D4842-4
Job Sheet 178084



Part No: D4842-4

Job Qty: 6 ea

POSITIVE RECALL

Part Name: Lower Cutter Body, RH



EFFECTIVE 10/10/18 AUTH D

Part Weight: 0 lbs

RELEASED D DATE 19012

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 8/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 16-692 DWG REV B U/R SHEETS 5,6 IPP REV: A NEW ISSUE JFS 13/04/30 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/16/18	7/16/18	0.00	0.00	Start Up Machining-3		Kt 2018-09-10
100	Bandsaw	6 pcs	7/16/18	7/16/18	0.00	0.01	Bandsaw1		Kt 2018-09-10
110	CNC Vertical Machining	6 pcs	7/16/18	7/16/18	0.06	6.82	HAAS1-5		Kt 2018-09-10
120	QC	6 pcs	7/16/18	7/16/18	0.00	0.00	QC2 Machining-3		Kt 2018-09-10
130	QC	6 pcs	7/16/18	7/16/18	0.00	0.00	QC8 Machining-3		VL 18-9-11
140	Outsource	6 pcs	7/16/18	7/16/18			ATG001-VC		CE 18-9-11
150	Packaging	6 pcs	7/16/18	7/16/18	0.00	0.00	Packaging2		SEB 27 2018
155	QC	6 pcs	7/16/18	7/16/18	0.00	0.00	QC5		38
180	Packaging	6 pcs	7/16/18	7/16/18	0.00	0.00	Packaging3-2		OCT 0 2018
190	QC21-SA	6 Ea	7/16/18	7/16/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 7.250"

Descriptions: 110 - 1-Machine per folio FB192

140 - Issue P/O to ATG: P0040883

180 - ***IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet 1" Thick Plate X 5" Wide	3.6180 ft (.603 ea)	90-Start up Operation	

5104641

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.000X5.000	4	13	0

Part Specifications

Id not be found.

Plex 5/28/18 7:20 AM Dart.lajeunesse.marie



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S109098



Part: D4842-4

Job No: 178084

Serial No/Batch: S109098

Revision:

Inspector:

Exp Date:

Instructions:

Date: 09/10/18

DART AEROSPACE LTD		Work Order:	178084
Description: Lower Cutter Body, RH		Part Number:	D4842-4
Inspection Dwg: D4842 Rev: B		Page 1 of 1	

INSPECTION SHEET

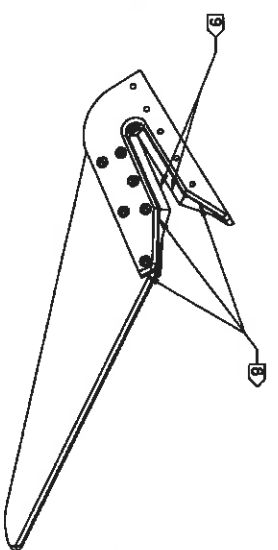
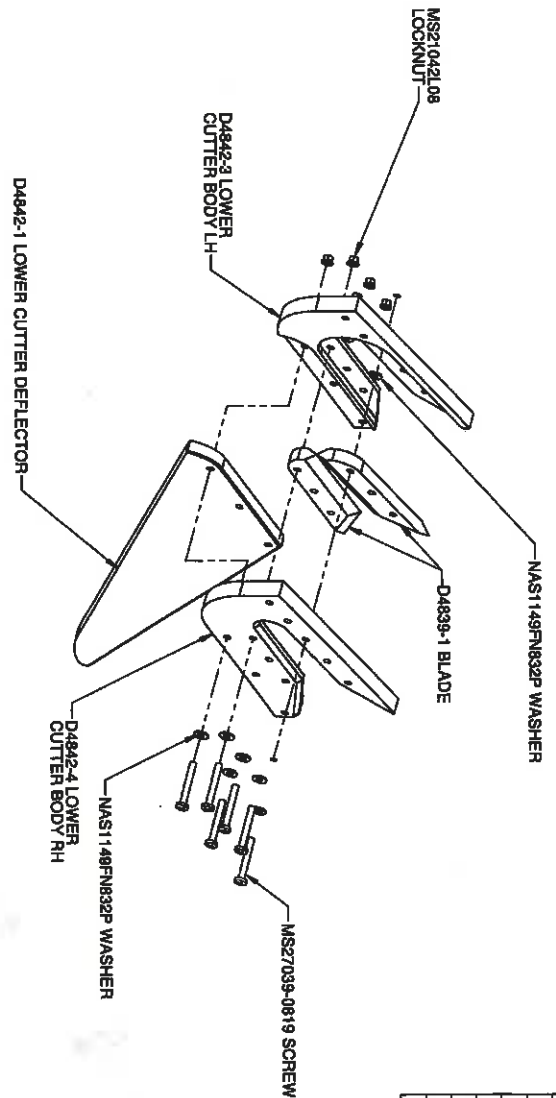
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.12 x 45°	+/-0.030 x +/-0.5°					
0.168	+0.003/-0.000					
3.68	+/-0.030					
0.168	+0.003/-0.000					
0.43	+0.010/-0.000					
5.50	+/-0.030					
6.78	+/-0.030					
6.52	+/-0.030					
1.51	+/-0.030					
1.47	+/-0.030					
0.24	+/-0.030					
0.90	+/-0.030					
4.580	+/-0.010					
4.220	+/-0.005					
2.110	+/-0.005					
2.400	+/-0.005					
1.200	+/-0.005					
0.400	+/-0.010					
4.601	+/-0.010					
Ø0.177	+0.005/-0.001					
6.133	+/-0.010					
4.440	+/-0.005					
3.240	+/-0.005					
2.040	+/-0.005					
1.020	+/-0.005					
0.501	+/-0.010					
30.2°	+/-0.5°					
23.7°	+/-0.5°					
6.8°	+/-0.5°					

Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (if necessary)		Date:	
---	--	-------	--

Rev	Date	Change	Revised By	Approved
A	15.10.26	New Issue	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	8	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NA51148FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT



D4842-041 LOWER CUTTER ASSEMBLY

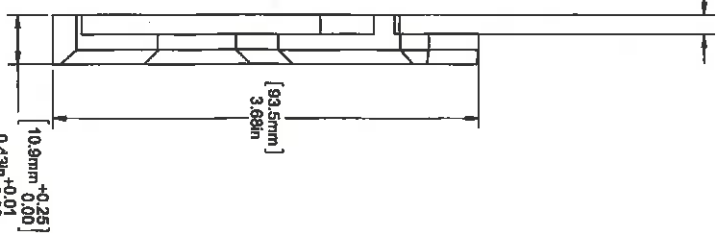
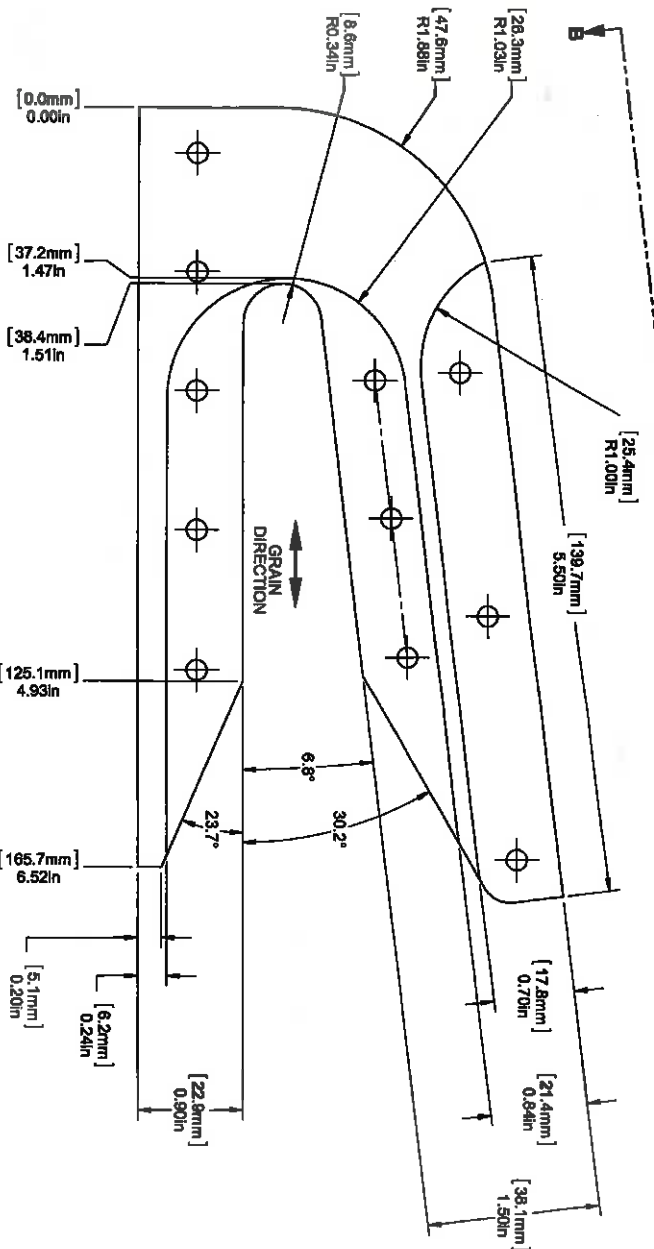
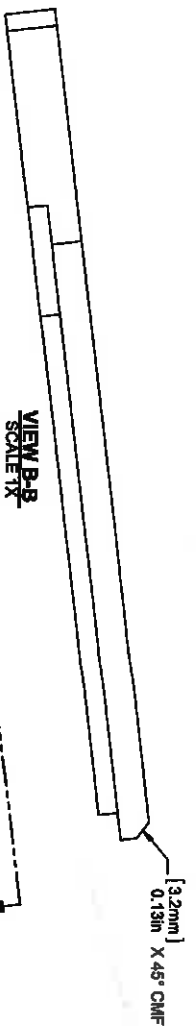
UNDER REVIEW

URF 16-692 WM
16-12-21

RELEASED
11 2013-10-31

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) PARTS: N/A
 - 5) BEVEL: SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE.
 - 7) WEIGHT: 2.79 lbs (1.28 KGS)
 - 8) APPLY RTV SEALANT TO ALL PAYING SURFACES UPON ASSEMBLY
 - 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

DART AEROSPACE LTD			
UNIVERSITY, ONTARIO, CANADA			
DRAWING NO.		REV. B	
D4842		SHEET 1 OF 6	
TITLE		SCALE	
LOWER CUTTER ASSY		N/A	
COPYRIGHT © 2013 BY DART AEROSPACE LTD			
ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT AND IMPORT CONTROLS ACT (R.S.C. 1985, c. 44).			
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT CONTROLLED BY THE EXPORT			



D4842-3 LOWER CUTTER BODY LH

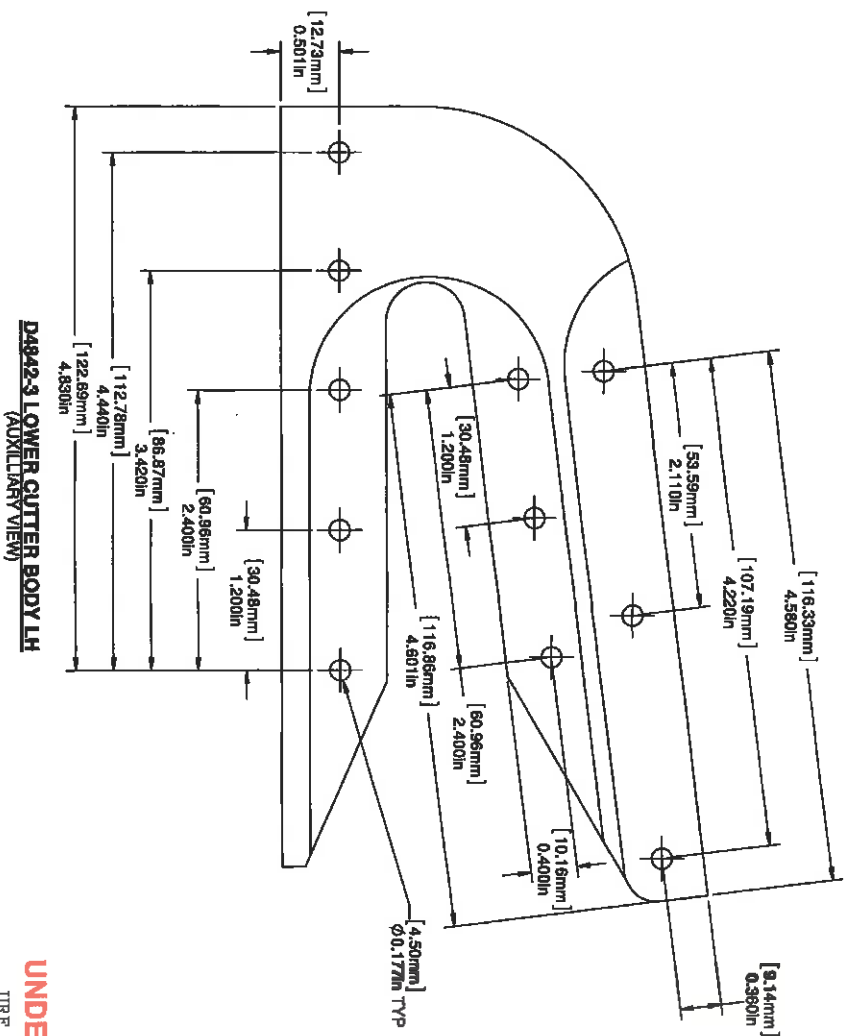
UNDER REVIEW

RELEASED
2013-10-31

- NOTES:
- 1) MATERIAL: 7075-T6 (OR 7061/7065/107065/117062) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4122/4123/4189/4187) OR
PER AMS-QQ-A-220/11 (REF DART SPEC W707518B)
 - 2) FINISH: HAND ANODIZE IAW MIL-A-8826 TYPE III, CLASS 2, COLOR BLACK, AS PER QSI 017;
 - 3) TOLERANCES: FINE FAY MIL-P-23877 J TYPE I, CLASS N, 1.2 MIL MAX, AS PER QSI 006;
 - 4) UNITS: DIMENSIONS PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) BREAK: SHOWN UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.49 (0.22) LBS
 - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4842-3.dwg

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DW	DRAWING NO.
CHECKED	AP	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	AP	REV. B
APPROVED	AP	D4842
DATE	13.10.17	LOWER CUTTER ASSY
		SHEET 3 OF 6
		SCALE
		NTS

16-12-21
URF 16-692
NM



D4842-3 LOWER CUTTER BODY LH
(AUXILIARY VIEW)

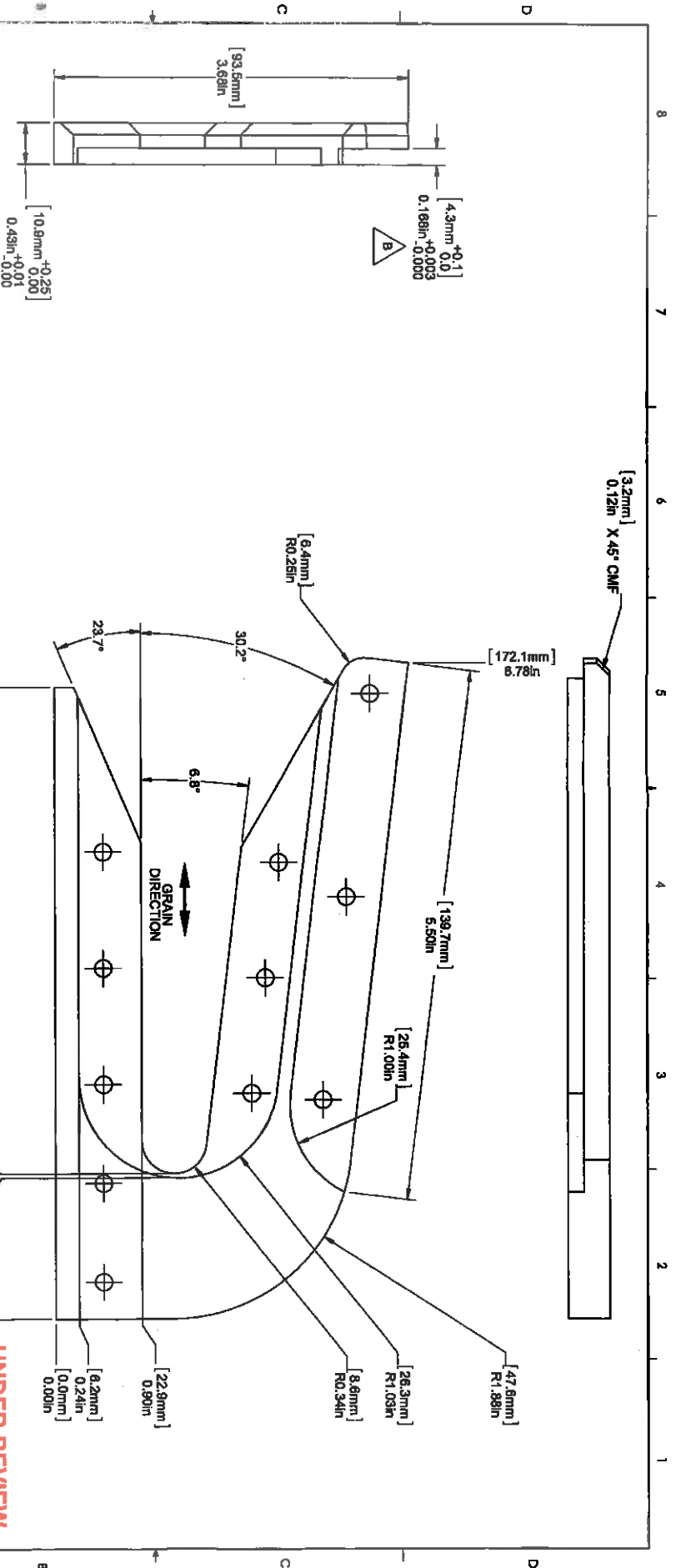
UNDER REVIEW
URF 16-692 WM
16-12-21

RELEASE
2013-10-31
JM

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DW	HANESBURY, ONTARIO, CANADA
CHECKED	AP	D4842
MFG. APPR.	AP	
APPROVED	AP	
DE APPR.	AP	
DATE	13.10.17	

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DW	HANESBURY, ONTARIO, CANADA
CHECKED	AP	D4842
MFG. APPR.	AP	
APPROVED	AP	
DE APPR.	AP	
DATE	13.10.17	

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DW	HANESBURY, ONTARIO, CANADA
CHECKED	AP	D4842
MFG. APPR.	AP	
APPROVED	AP	
DE APPR.	AP	
DATE	13.10.17	



D4842-4 LOWER CUTTER BODY RH

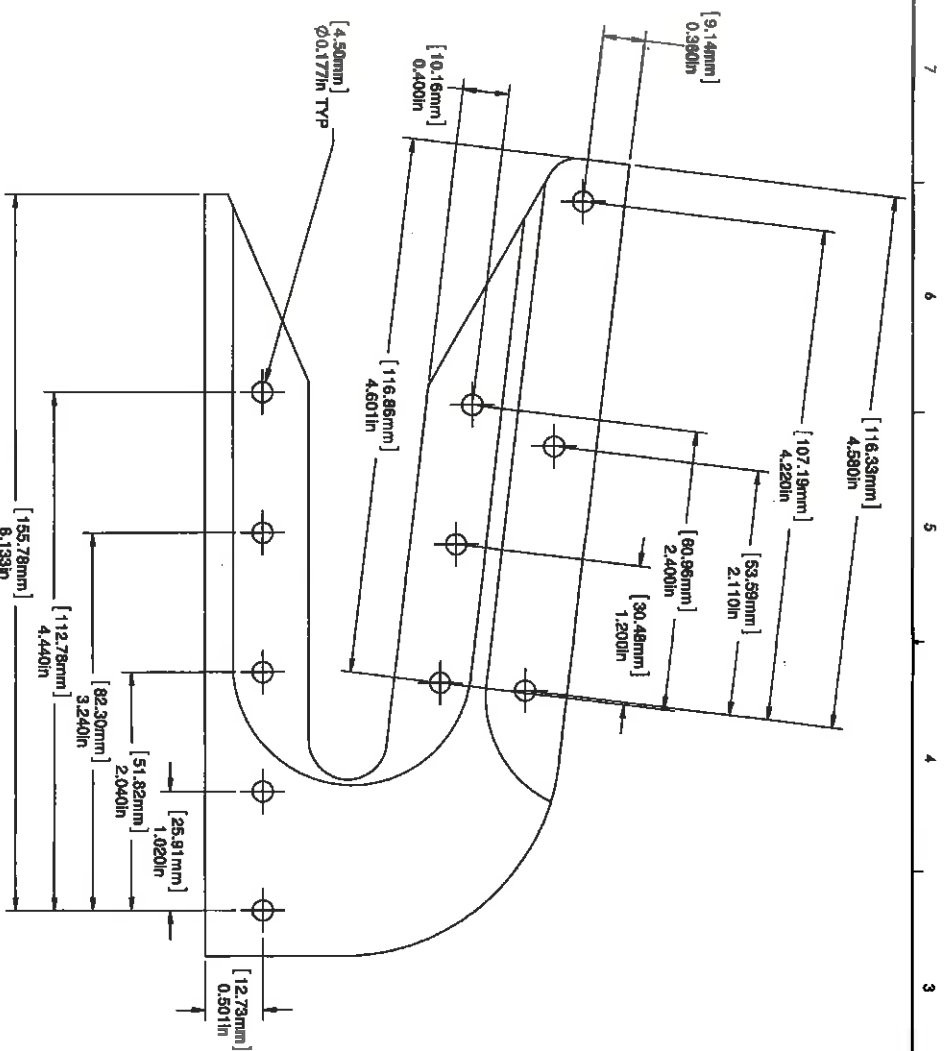
RELEASED
2013-10-31

UNDER REVIEW

UREP 16-692 WM
16-12-21

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DWG	HAWESBURY, ONTARIO, CANADA
CHECKED	AP	D4842
MFG. APPR.	AP	REV. B
APPROVED	AP	SHEET 5 OF 6
DATE	13.10.17	LOWER CUTTER ASSY
		SCALE
		NTS

- NOTES:
- 1) MATERIAL: 7075-T6 (OR 7661/7851/7851/782) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4122/6123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075/782)
 - 2) FINISH: HARD ANODIZE (AW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME (AW MIL-P-23377) TYPE I, CLASS N, 1-2 MIL MAX, AS PER CSI 005.
 - 3) TOLERANCES: PER DART CSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.49 LBS (0.22 KGS)
 - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL, FILE: D4842-4.IGES



D4842-4 LOWER CUTTER BODY RH
(AUXILIARY VIEW)

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DW	HAWKSBURY, ONTARIO, CANADA
CHECKED	A.P.	DRAWING NO. D4842
MFG. APPR.	AP	REV. B
APPROVED	AP	SHEET 8 OF 8
DE APPR.	AP	SCALE
DATE	13.10.17	MTS

UNDER REVIEW
URF 16-692 MM
16-12-21

RELEASE
2013-10-31

Copyright © 2013 by DART Aerospace Ltd.
All Rights Reserved. No part of this drawing may be reproduced or transmitted in any form or by any means electronic or mechanical, including photocopying, recording, or by any information storage and retrieval system, without permission in writing from DART Aerospace Ltd.

DART AEROSPACE LTD		Work Order:	
Description: Lower Cutter Body, RH		Part Number:	D4842-4
Inspection Dwg: D4842	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.12 x 45°	+/-0.030 x +/-0.5°	0.130x45	✓		Kt-05	vern.
0.168	+0.003/-0.000	0.1695	✓		K1-01	micrometre
3.68	+/-0.030	3.68	✓		Kt-05	vern.
0.168	+0.003/-0.000	0.170	✓		"	"
0.43	+0.010/-0.000	0.436	✓		"	"
5.50	+/-0.030	5.50	✓			
6.78	+/-0.030	6.78	✓			
6.52	+/-0.030	6.52	✓			
1.51	+/-0.030	1.51	✓			
1.47	+/-0.030	1.47	✓			
0.24	+/-0.030	0.24	✓			
0.90	+/-0.030	0.900	✓			
4.580	+/-0.010	4.580	✓			
4.220	+/-0.005	4.220	✓			
2.110	+/-0.005	2.110	✓			
2.400	+/-0.005	2.400	✓			
1.200	+/-0.005	1.200	✓			
0.400	+/-0.010	0.400	✓			
4.601	+/-0.010	4.601	✓			
Ø0.177	+0.005/-0.001	0.177	✓			
6.133	+/-0.010	6.133	✓			
4.440	+/-0.005	4.440	✓			
3.240	+/-0.005	3.240	✓			
2.040	+/-0.005	2.040	✓			
1.020	+/-0.005	1.020	✓			
0.501	+/-0.010	0.501	✓			
30.2°	+/-0.5°	30.2°	✓			
23.7°	+/-0.5°	23.7°	✓			
6.8°	+/-0.5°	6.8°	✓			

Measured by: <i>KJ</i>	Checked by: <i>JK</i>	QC Inspector:
Date: 2018-09-10	Date: 18-9-11	Date:

Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised By	Approved
A	15.10.26	New Issue	KJ	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040983

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO040983
PO Date: 9/11/18
Due Date: 10/5/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178084	D4842-4	Lower Cutter Body, RH Issue P/O to ATG :	Firmed	-	10/5/18	6 pcs	0 pcs	6 pcs	\$11.10/pcs	\$66.60
					6 X	SEP 27 2018					
2	178085	D4842-3	Lower Cutter Body, LH Issue P/O to ATG : 1- Black Anodize as per Dwg D4842	Firmed	-	10/5/18	6 pcs	0 pcs	6 pcs	\$11.10/pcs	\$66.60
					6 X	SEP 27 2018					
3	182247	647.7912	Clip ISSUE P/O: Hard Anodize, Color Black and Prime As Per Dwg. 647.7900	Firmed	-	10/5/18	56 pcs	0 pcs	56 pcs	\$10.45/pcs	\$585.20
4	181356	647.1613	Doubler Issue P/O to ATG : 1- Black Anodize as per Dwg, SEE NOTE #3 2- PRIME AS PER DWG, SEE NOTE #3 Certification of Conformity is required	Firmed	-	10/5/18	40 pcs	0 pcs	40 pcs	\$8.75/pcs	\$350.00
					40 X	SEP 27 2018					
5	181374	647.7918	Bracket ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2)	Firmed	-	10/5/18	30 pcs	0 pcs	30 pcs	\$11.75/pcs	\$352.50
6	179154	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300	Firmed	-	10/5/18	16 pcs	0 pcs	16 pcs	\$18.95/pcs	\$303.20

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200 —

PURCHASE ORDER
PO040983

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	179155	646.3311	RH Half - Upper Cutter Assembly Issue P/O to ATG :	Firmed	-	10/5/18	16 pcs	0 pcs	16 pcs	\$18.95/pcs	\$303.20
8	178573	RBT400213-1	Tab Bender Body -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	10/5/18	12 pcs	0 pcs	12 pcs	\$13.35/pcs	\$160.20
12 X SEP 20 2018											
Grand Total:											\$2,187.50

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/17/18 10:13 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916129

Date: 26-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 6 ea	Part: D4842-4 ✓ Lower Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 23732 PO: PO040983 ✓ Line: 1	Rev: B	
✓ 6 ea	Part: D4842-3 ✓ Lower Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 23733 PO: PO040983 ✓ Line: 2	Rev: B	
✓ 40 ea	Part: 647.1613 ✓ Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23735 PO: PO040983 ✓ Line: 4	Rev: A	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>26/09/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			

DAS
38
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916129

Date: 26-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	receipt.	